

**Work Order ID 64939**

Tuesday, January 04, 2011 11:57:37 AM

Page 1

Item ID: D350-578-013

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw

Start Date: 1/4/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/11/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: *mf* Date: *11-01-04*

Tooling:

Date:

QC: Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

DSI 9539

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels per PPP D350-578-013 and DSI9539  
CHG001*Sulob**OK for BR 11/01/05*

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

*11/1/6 (2x) SP*

110

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

*Sulob**(+2)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64939**

Tuesday, January 04, 2011 11:57:37 AM

Page 2

Item ID: D350-578-013

Accept

Setup Start

Revision ID:

Stop

Item Name: Bearpaw

Start Date: 1/4/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 1/11/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-578-013 and DSI9539

Location:

PPP Rev: ONE-A

11/1/06  
MF

130

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

11/01/06  
MF  
11-01-06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, January 04, 2011 11:57:37 AM

Page 1

Work Order ID: 64939

Parent Item: D350-578-013

Parent Item Name: Bearpaw

Start Date: 1/4/2011

Required Date: 1/11/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 11.01.04 NEW ISSUE VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S <sub>2</sub> D2182B050 → measure @ 5.0" S <sub>2</sub> 11/1/06 Clamp Cushion Black		Manufactured	No			105	Each	0.0000	6	12		11/1/06	
S <sub>2</sub> D2274 Radius Block		Manufactured	No			105	Each	198.0000	12	24		11/1/06	
<div> <div>Location</div> <div>ST010</div> <div>61361</div> <div>63990</div> <div>64420</div> </div> <div> <div>Loc Qty</div> <div>198</div> <div>1</div> <div>11</div> <div>186</div> </div> <div> <div>Loc Code</div> <div></div> <div>5</div> <div>19</div> <div></div> </div>													
S <sub>2</sub> D2529 Washer		Manufactured	No			105	Each	924.0000	12	24		11/1/06	
<div> <div>Location</div> <div>ST017</div> <div>64127</div> </div> <div> <div>Loc Qty</div> <div>924</div> <div>924</div> </div> <div> <div>Loc Code</div> <div></div> <div>24</div> </div>													
S <sub>2</sub> D2438 Clamp		Manufactured	No			105	Each	103.0000	6	12		11/1/06	
<div> <div>Location</div> <div>ST256</div> <div>63999</div> <div>ST456</div> <div>60852</div> </div> <div> <div>Loc Qty</div> <div>100</div> <div>100</div> <div>3</div> <div>3</div> </div> <div> <div>Loc Code</div> <div></div> <div>11</div> <div></div> <div>1</div> </div>													
S <sub>2</sub> D4297-1 Bearpaw		Manufactured	No			105	Each	0.0000	2	4		11/01/06	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, January 04, 2011 11:57:37 AM

Page 2

Work Order ID: 64939

Parent Item: D350-578-013

Parent Item Name: Bearpaw

Start Date: 1/4/2011

Required Date: 1/11/2011

Start Qty: 2.00

Required Qty: 2.00

AN4-17A

Purchased

No

105

Each

518.0000

12

24

Bolt

## Location

## Loc Qty

## Loc Code

ST358

500

116400

100

116419

400

ST359

18

112314

18

105

Each

3,451.000

12

24

NAS1149D0463J

Purchased

No

Washer

## Location

## Loc Qty

## Loc Code

ST297

2800

116304

2800

ST298

651

110914

4

115622

38

116025

118

116289

491

105

Each

4,180.000

12

24

MS21042L4

Purchased

No

Nut

## Location

## Loc Qty

## Loc Code

ST300

4180

1123143

2

115589

10

115621

668

116188

3500

Tuesday, January 04, 2011 11:57:37 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-578 REV. F OR EARLIER  
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D350-578 REV. 1 OR EARLIER

REF. TCCA STC: SH93-4  
REF. FAA STC: SR00028NY  
REF. FAA STC: SR00029NY  
REF. EASA STC: 10016984

REFERENCE ONLY

## 1.0 PURPOSE

The purpose of this DSI is to add the D350-578-013 Bearpaw Kit, which is similar to the existing D350-578-011 Bearpaw Kit, except that the machined pockets have been removed per customer preference. The D350-578-013 Kit installs in the same way as the D350-578-011 Kit.

## 2.0 INSTALLATION PROCEDURE

- 2.1 Jack up the aircraft. Ensure the skidtubes are serviceable.
- 2.2 If the Bearpaws are being installed on Dart Skidtubes remove the D3537-1 or D2648-1 Wearpads prior to installing the bearpaws. It is not necessary to remove the Dart Wearplates and gaskets. Re-install attachment hardware into open inserts.
- 2.3 Position the D4297-1 Bearpaw on the aft end of each skidtube as shown in Figure 2.
- 2.4 Install the D2438 clamps with the hardware as shown in Figure 3.  
**Caution: The torque on the nuts should be limited to 20 in-lb (2.3 Nm).**
- 2.5 The D4297-1 Bearpaw may be relieved to clear wearshoe mounting screws provided the relief leaves 0.375" (9.53mm) thickness.
- 2.6 Lower the aircraft.

## 3.0 WEIGHT AND BALANCE

Installation	Weight	Lateral		Longitudinal	
		Arm	Moment	Arm	Moment
D350-578-013 Bearpaw Kit	17.60 lb 8.00 kg	0.0 in 0.0 m	0.0 in-lb 0.0 m-kg	157.0 in 3.99 m	2763.2 in-lb 31.92 m-kg

## 4.0 PARTS LIST


QTY. -013	PART NUMBER	DESCRIPTION
X	D350-578-013	Bearpaw Kit
6	D2182B050	Rubber Cushion
12	D2274	Radius Block
12	D2529	Washer
6	D2438	Clamp
2	D4297-1	Bearpaw
12	AN4-17A	Bolt
12	NAS1149D0463J	Washer
12	MS21042L4	Nut or (MS21042-4)

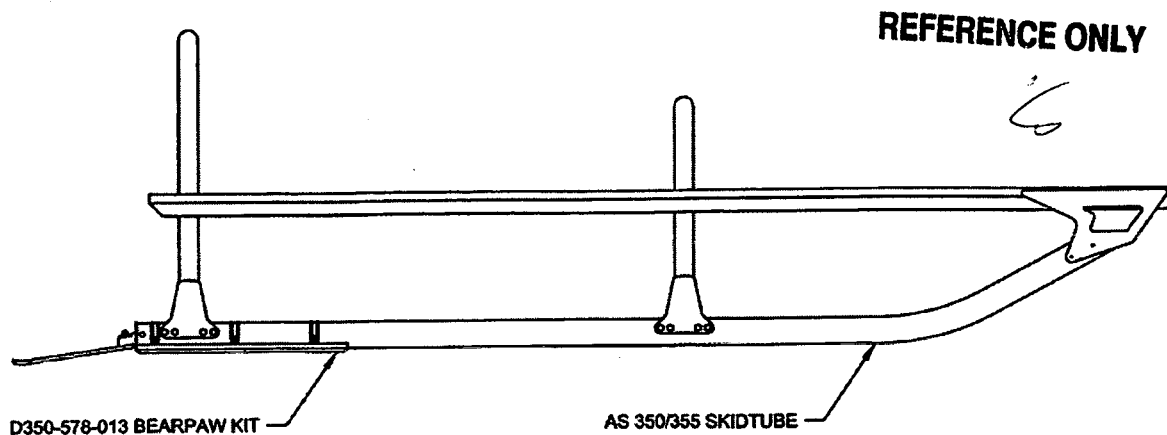
CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

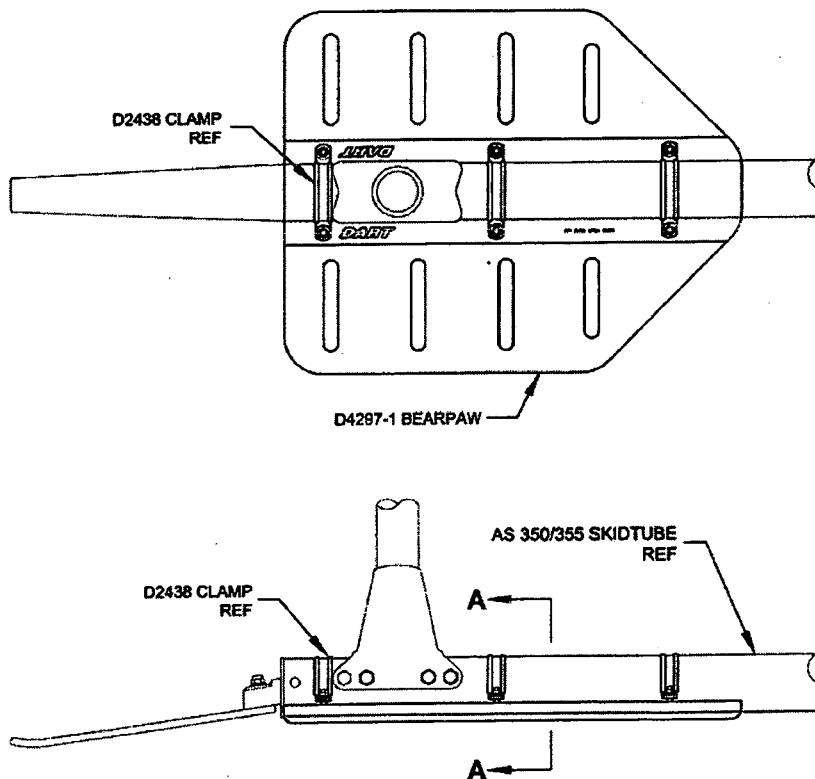
BY:   
D. SHEPHERD (DE # 02)

DATE: 10.12.15  
CERT. NO.: SH93-4  
ISSUE NO.: 8

A	NEW ISSUE	RF	10.12.15
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9539	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BEARPAW KIT	NTS
DATE	10.12.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



**Figure 1. D350-578-013 Bearpaw Kit**



**Figure 2. Bearpaw Location (Side View & top View)**

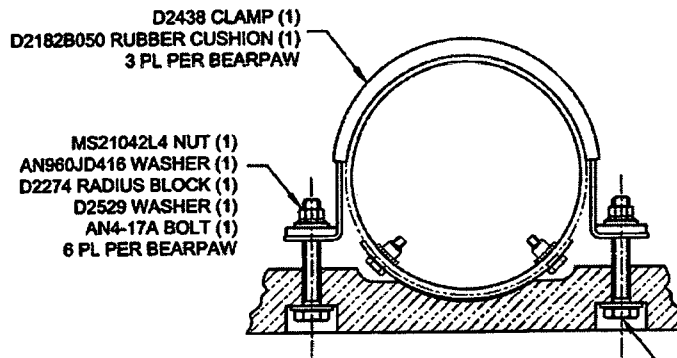
CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

**APPROVED**  
BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 10.12.15  
CERT. NO.: SH93-4  
ISSUE NO.: 8

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>RF</del>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9539	SHEET 2 OF 3
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	BEARPAW KIT	NTS
DATE	10.12.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

REFERENCE ONLY



**SECTION A-A**

ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

**Figure 3. Clamping Detail (Section A-A)**

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED

BY: *[Signature]*  
D. SHEPHERD (DE # 02)

DATE: 10.12.15  
CERT. NO.: SH93-4  
ISSUE NO.: 8

DESIGN	RF	<b>DART AEROSPACE LTD</b>	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<del>RF</del>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9539	SHEET 3 OF 3
APPROVED	<del>RF</del>	TITLE	SCALE
DE APPR.	<del>RF</del>	BEARPAW KIT	NTS
DATE	10.12.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			